

Work Order ID 84961

84961

Page 1

May-29-12 12:46:26 PM

Item ID: D4541-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 29/05/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 12/06/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/29 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4541	B

73

100 0.00

100

Waterjet

Memo

FLOW CNC Waterjet

1- Cut as per dwg

6061 . 032

Prog rev: B

Dwg rev: B

2- Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

Quality Control

B12-6-7

B12-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 29/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

576668

13

150

Identify as per dwg & Stock Location: **GA**

0.00

150

Packaging

Memo

0.00

Packaging

30

12/6/12

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/11

me

12-06-08

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Picklist Print

May-29-12 12:46:29 PM

Page 1

Work Order ID: 84961

84961

Parent Item: D4541-7

D4541-7

Parent Item Name: Bracket

Start Date: 29/05/2012

Required Date: 12/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as
per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	276.5460	0.258	0.543158	1.5		

M6061T6S 032

6061-T6 Sheet 0.032"

**

B12-67

Location

Loc Qty

Loc Code

MAT021

276.546

118106

46.606

120218

24.77

120285

42.24

121099

162.93

121099

3

W/O:		WORK ORDER CHANGES					
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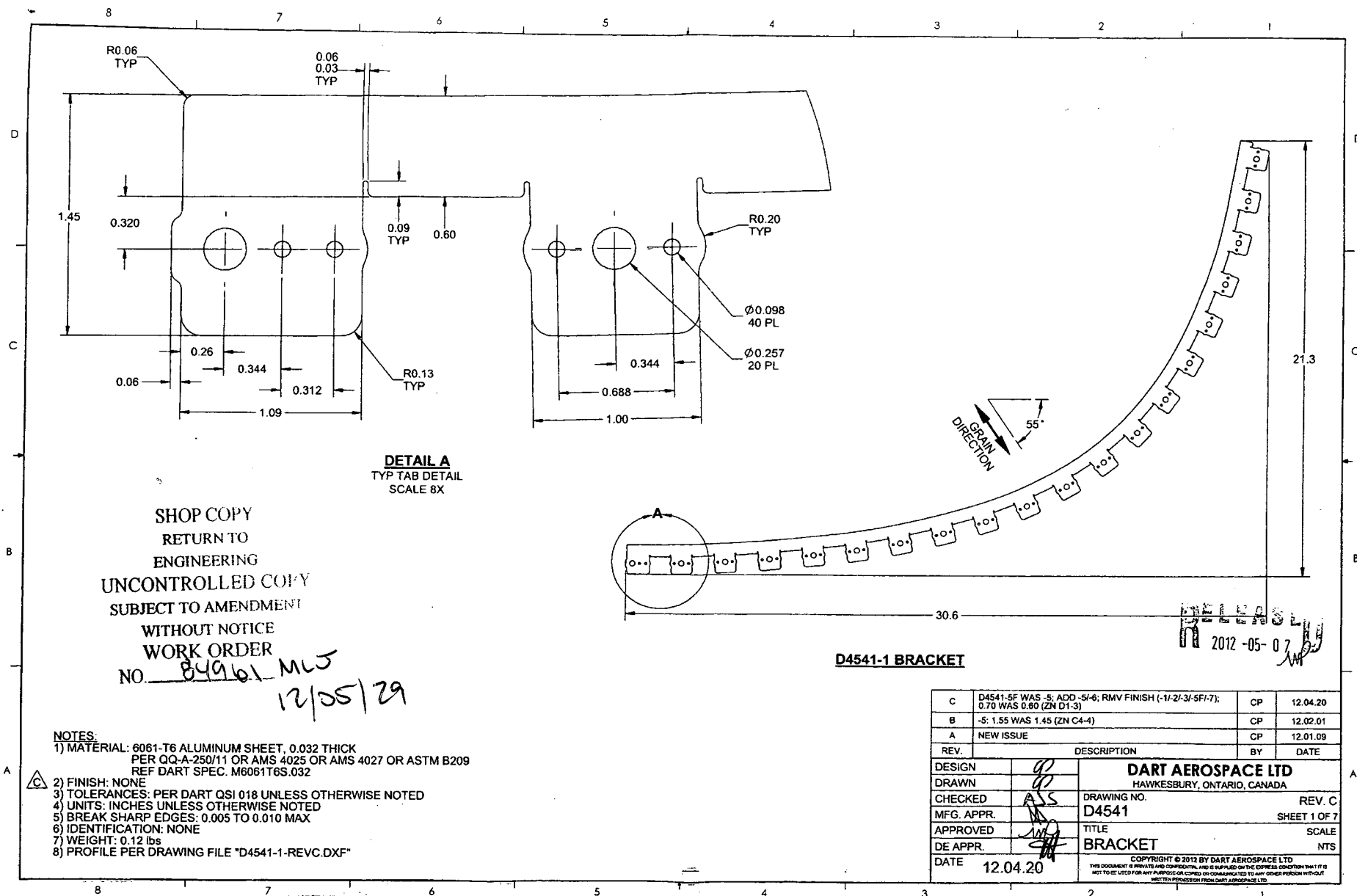
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 84961 MJS
12/05/29

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-1-REV.C.DXF"

D4541-1 BRACKET

C	D4541-SF WAS -S; ADD -S/4-6; RMV FINISH (-1/2/-3/-5/-7); 0.70 WAS 0.50 (ZN D1-3)	CP	12.04.20
B	-S: 1.55 WAS 1.45 (ZN C4-4)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4541	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.04.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

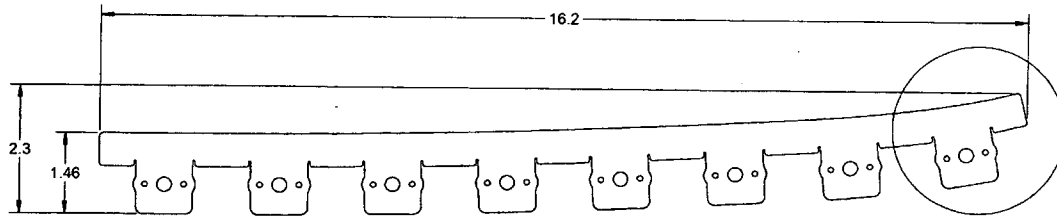
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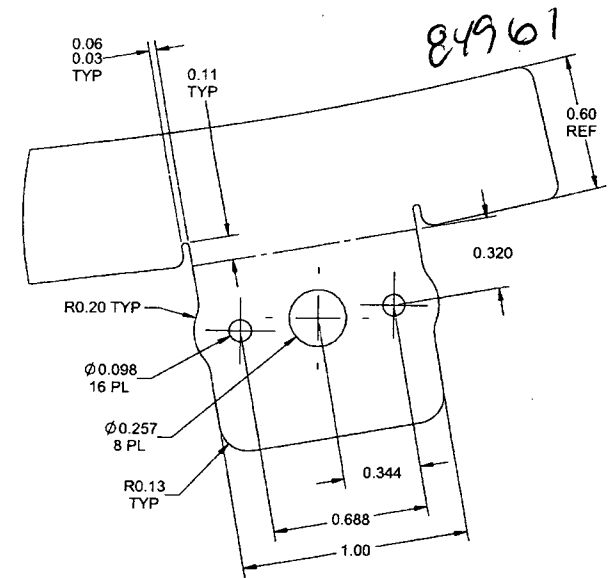


D4541-7 BRACKET



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- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
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REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4541-7-REVC.DXF"



DETAIL G
TYP TAB DETAIL
SCALE 4X

2012-05-07

DESIGN	go	DART AEROSPACE LTD	
DRAWN	go	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4541	SHEET 7 OF 7
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	BRACKET	NTS
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